

Date: Monday, 1/30/2006 8:08:05 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HIGH AFT X-TUBE 412		
Job Number	: 25652					
Estimate Number	: 10559					
P.O. Number	: N/A			Part Number	: D412664203	
This Issue	: 1/30/2006 S.O. No. : N/A			Drawing Number	: D412-664-243 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: B	
Previous Run	: 25651			Material	: N/A	
Written By	: See Comment Below			Due Date	: 2/28/2006	
Checked & Approved By	: PJA 06.01.30			Qty:	1 Um: Each	
Comment	: Est Rev:E 04.02.16 Reformat; Added D3189-1 K/DS					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
<b>Comment:</b> DOCUMENT CONTROL Photocopy bluefile and create labels as per PPP D412-664-203 CHG 003			
2.0	D6009129	Crosstube Material	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part number Description Batch 1 D6009-129 Crosstube <u>18.25047</u> Check OD = 3.500", ID = 2.250"			
3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE	
<b>Comment:</b> MORI SEIKI CNC LATHE LARGE  1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA166  2-Turn first side as per Folio FA166  3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.			
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
<b>Comment:</b> INSPECT ALL DIM TO DIM SHEET			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/30/2006 8:08:05 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 25652

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA166

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

3-Polish entire outside surface of crosstube

4- Remove sand and plugs

5-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243

3C 06-05-08

6.0 QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

3C 06-05-08

7.0 QC8

SECOND CHECK



Comment: SECOND CHECK

MS 06/05/09

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

3C 06-05-10

Chemical Conversion Coat as per QSI 005 4.1

9.0 QC3/5

INSPECT WORK/WING WALK



Comment: Inspect work & Chemical conversion Coat

D 06-5-10

10.0 BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

D 06-5-11

11.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06-05-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/30/2006 8:08:05 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 25652

Part Number: D412664203

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

12.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
------	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

- 1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551 *Prn 06-05-150*
- 2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check *Prn 06-05-150* dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.
- 3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243 *Prn 06-05-150*

13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Prn 06-05-150*

14.0	OUTSIDE SERVICE	OUTSIDE SERVICES
------	-----------------	------------------



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 0380r

Issue P/O: 1260 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

*C 06/05/16 ①*

15.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

*Prn 06/05/18 ①*

16.0	QC6	DIMENSIONAL CHECK.
------	-----	--------------------



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

17.0	SPRAY PAINTING	SPRAY PAINTING
------	----------------	----------------



Comment: SPRAY PAINTING

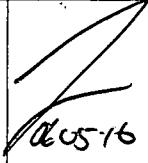
1-Prime inside and outside crosstube as per QSI 005 4.2

*FC 06 05 24 ①*  
*M 06 05 25 ①*

2-Paint outside crosstube with White Imron as per QSI 005 4.2

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/05/16	13.1	Add QC5 QC5 inspected work 06/05/16 permanent change 2	E	06-05-31			 06/05/16

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/05/31  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

Date: Monday, 1/30/2006 8:08:06 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 25652

Part Number: D412664203

Job Number:



Seq. #:	Machine Or Operation:	Description :	
18.0	QC14	Inspect Spray Paint	<i>1/30-26 ①</i>
<b>Comment:</b> Inspect Spray Paint Wrap in plastic bag to protect from scratches			
19.0	D2856600	Abrasion Strip	<i>1/30-26-5-29</i>
<b>Comment:</b> Qty.: 1.7640 f(s)/Unit Total : 1.7640 f(s) Pick: Qty Part number Description Batch 2 D2856-600(Cut to 10.090") Abrasion Strip <i>B24328</i>			<i>PT</i>
20.0	D2856600	Abrasion Strip	<i>1/30-26-5-29</i>
<b>Comment:</b> Qty.: 1.0080 f(s)/Unit Total : 1.0080 f(s) Pick: Qty Part number Description Batch 2 D2856-600(Cut to 10.870") Abrasion Strip <i>B24328</i>			<i>PT</i>
21.0	D28961	Support	<i>1/30-26-5-29</i>
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part number Description Batch 1 D2896-1 Support <i>B21740</i>			<i>PT</i>
22.0	D31891	Chafing Shield	<i>1/30-26-5-29</i>
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part number Description Batch 2 D3189-1 Chafing Shield <i>B25658</i>			<i>PT</i>
23.0	MS2192028	Clamp	<i>1/30-26-5-29</i>
<b>Comment:</b> Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part number Description Batch 4 MS21920-28 Clamp <i>M100479</i>			<i>PT</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/30/2006 8:08:06 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 25652

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

24.0 MS2192030 Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 MS21920-30 Clamp *M100151*

*IT* 06-5-29

25.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*DP* 06-5-30

26.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

27.0 AN640A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

*4* *AN6-40a* Bolt *M19099* ✓

28.0 AN641A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

*2* *AN6-41A* Bolt *M19633* ✓

29.0 AN960JD616 Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit *AN960JD616*

Qty Part number Description Batch

*18* *AN960JD616* Washer *M100191* ✓

30.0 MS21042L6 Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

6 MS21042L6 Nut *M19099* ✓

*AB* 06/05/2006

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/30/2006 8:08:06 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 25652

Part Number: D412664203

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

31.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

32.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-203

Location: PG5

PPP Rev: D

R 06/05/30 ①

33.0	DC	DOCUMENT CONTROL
------	----	------------------



Comment: DOCUMENT CONTROL

Inspection Level 21

① 06/05/31

Job Completion



u 06.05.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25652
Description: Crosstube Assembly (412 High Aft)	Part Number:	D412-664-243
Inspection Dwg: D412-664-243 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.687	✓		
	2.748	+0.005/-0.000	2.752	✓		
	2.884	+0.005/-0.000	2.887	✓		
	3.019	+0.005/-0.000	3.021	✓		
	3.163	+0.005/-0.000	3.166	✓		
	3.308	+0.005/-0.000	3.310	✓		
	3.429	+0.005/-0.000	3.432	✓		
	2.990	+0.005/-0.000	2.992	✓		
	2.618	+0.005/-0.000	2.622	✓		
	0.200	+/-0.010	.205	✓		
	R0.063	+/-0.010	.063	✓		
	R0.500	+/-0.010	.500	✓		
	4.971	+/-0.001	4.972	✓		
SIDE B	2.684	+0.005/-0.000	2.688	✓		
	2.748	+0.005/-0.000	2.752	✓		
	2.884	+0.005/-0.000	2.887	✓		
	3.019	+0.005/-0.000	3.023	✓		
	3.163	+0.005/-0.000	3.165	✓		
	3.308	+0.005/-0.000	3.310	✓		
	3.429	+0.005/-0.000	3.431	✓		
	2.990	+0.005/-0.000	2.992	✓		
	2.618	+0.005/-0.000	2.622	✓		
	0.200	+/-0.010	.200	✓		
	R0.063	+/-0.010	.063	✓		
	R0.500	+/-0.010	.500	✓		
	4.971	+/-0.001	4.975	✓		
	124.09	+/-0.020	124.09	✓		

Measured by:	BSG	Audited by:	MJS	Prototype Approval:	N/A
Date:	06.05.09	Date:	06/05/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue	(P/O D412-664-203)	KJ/JLM

**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED /	APPROVED /	DRAWING NO. D412-664-243	REV. B SHEET 1 OF 3
DATE 05.02.04	TITLE CROSSTUBE ASSEMBLY (412 HI AFT)		SCALE NTS
A	01.10.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

**RELEASED**  
05-06-09 AF

Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
1	D2856-600-1087	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP
2	D3189-1	CHAFING SHIELD

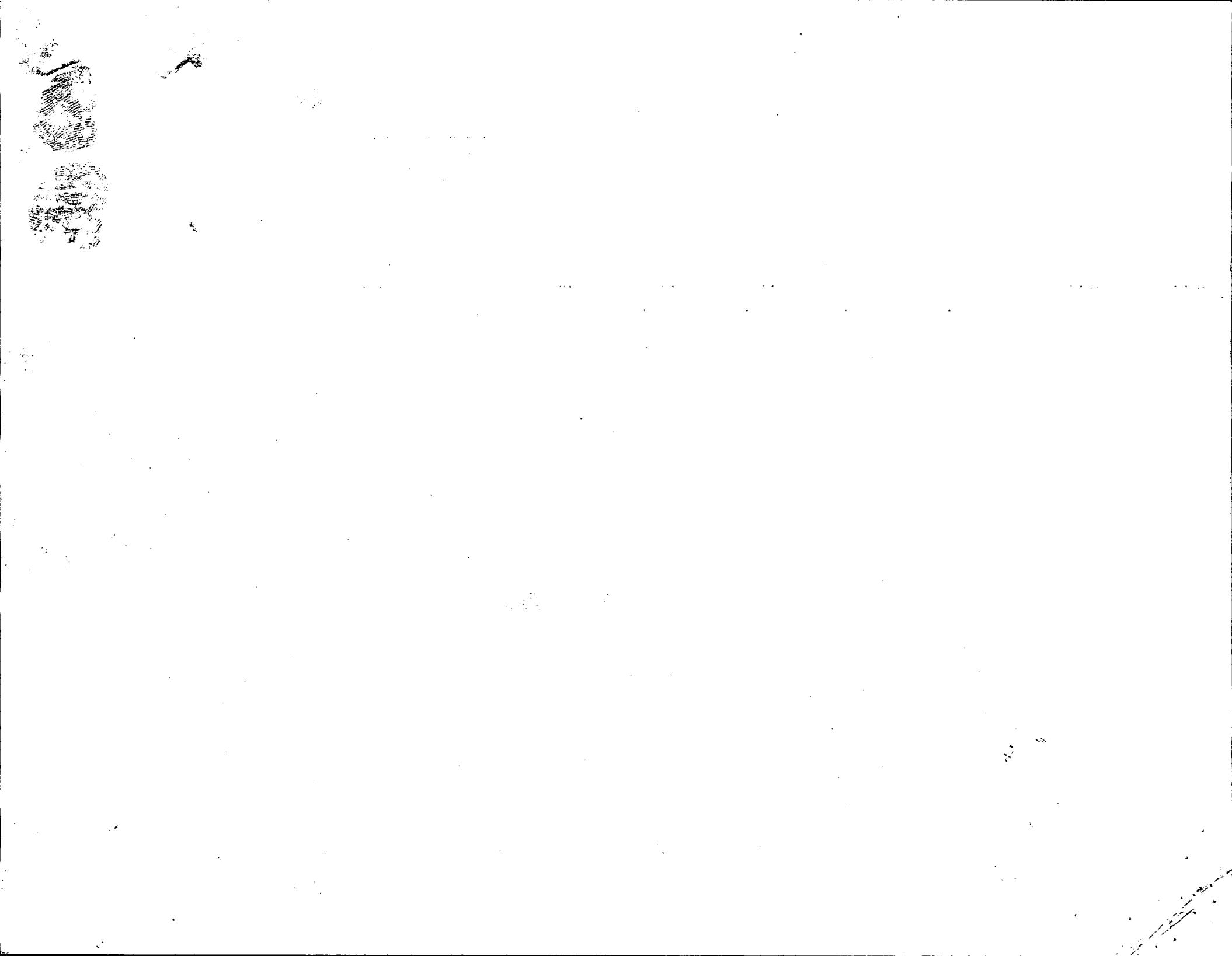
**GENERAL NOTES:**

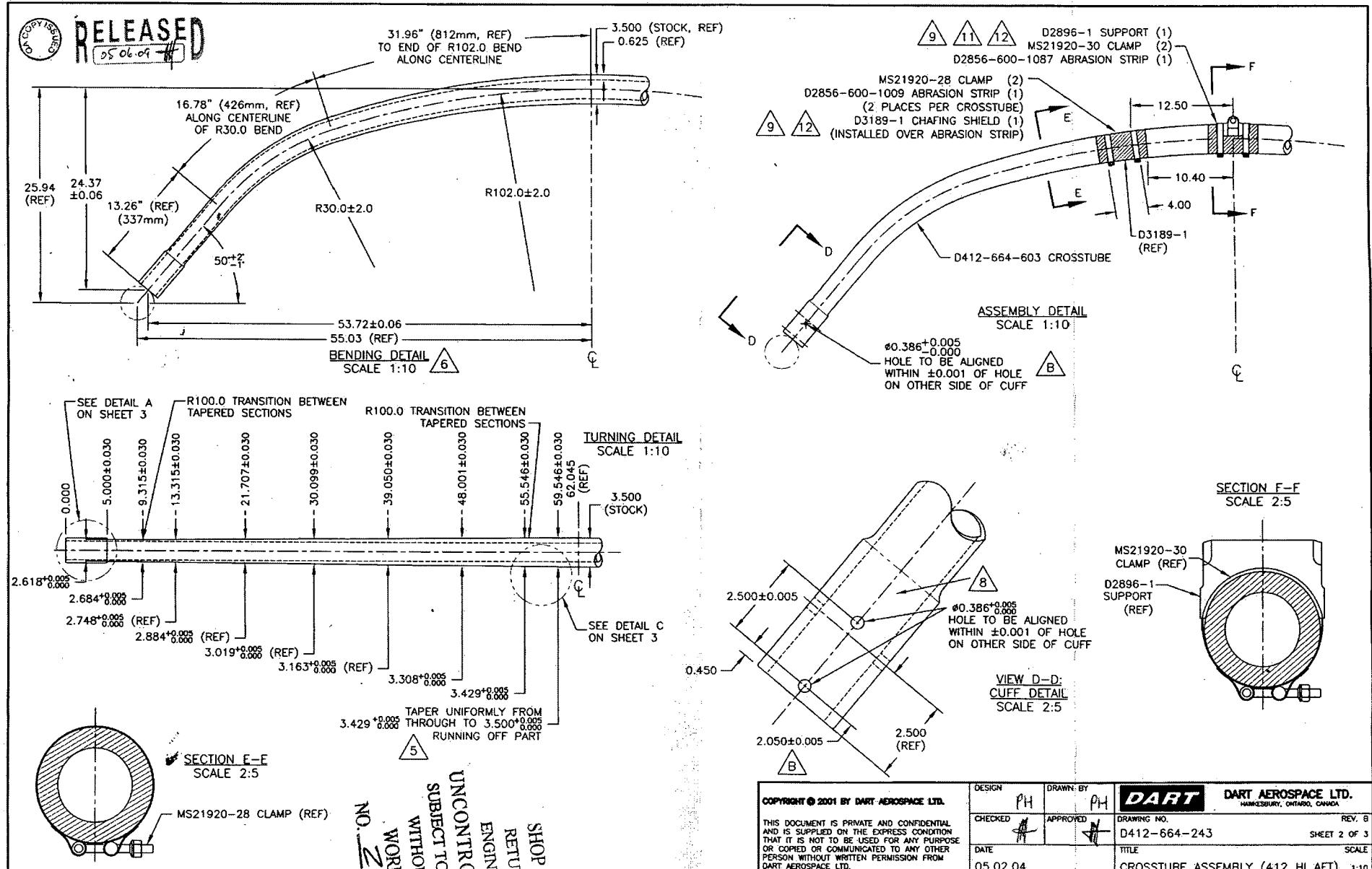
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129  
FINISHED LENGTH =  $124.09 \pm 0.020$
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 AND D2856-600-1087 ABRASION STRIPS WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2896-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25652

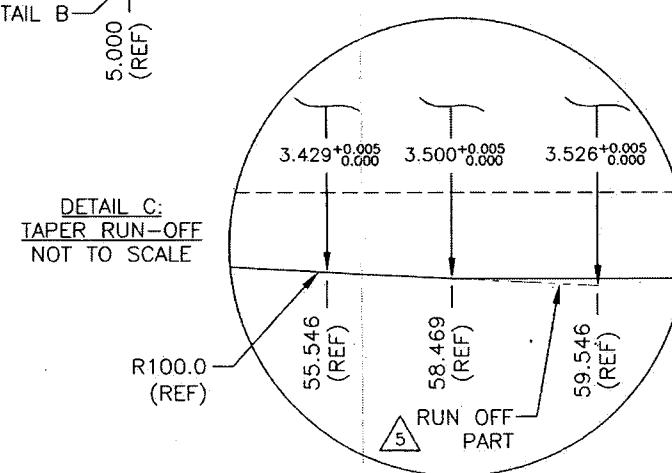
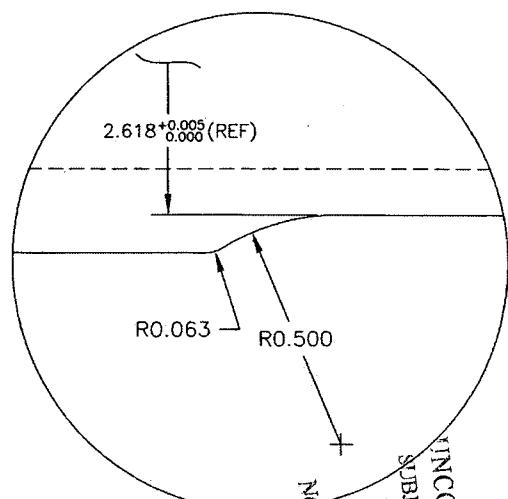
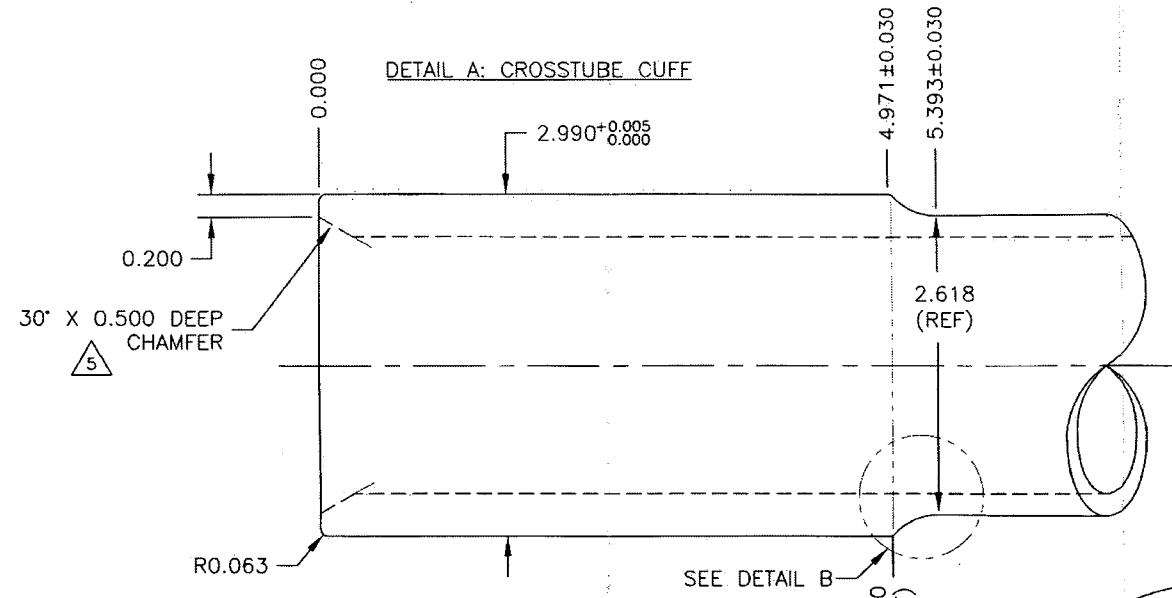
**Copyright © 2001 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.





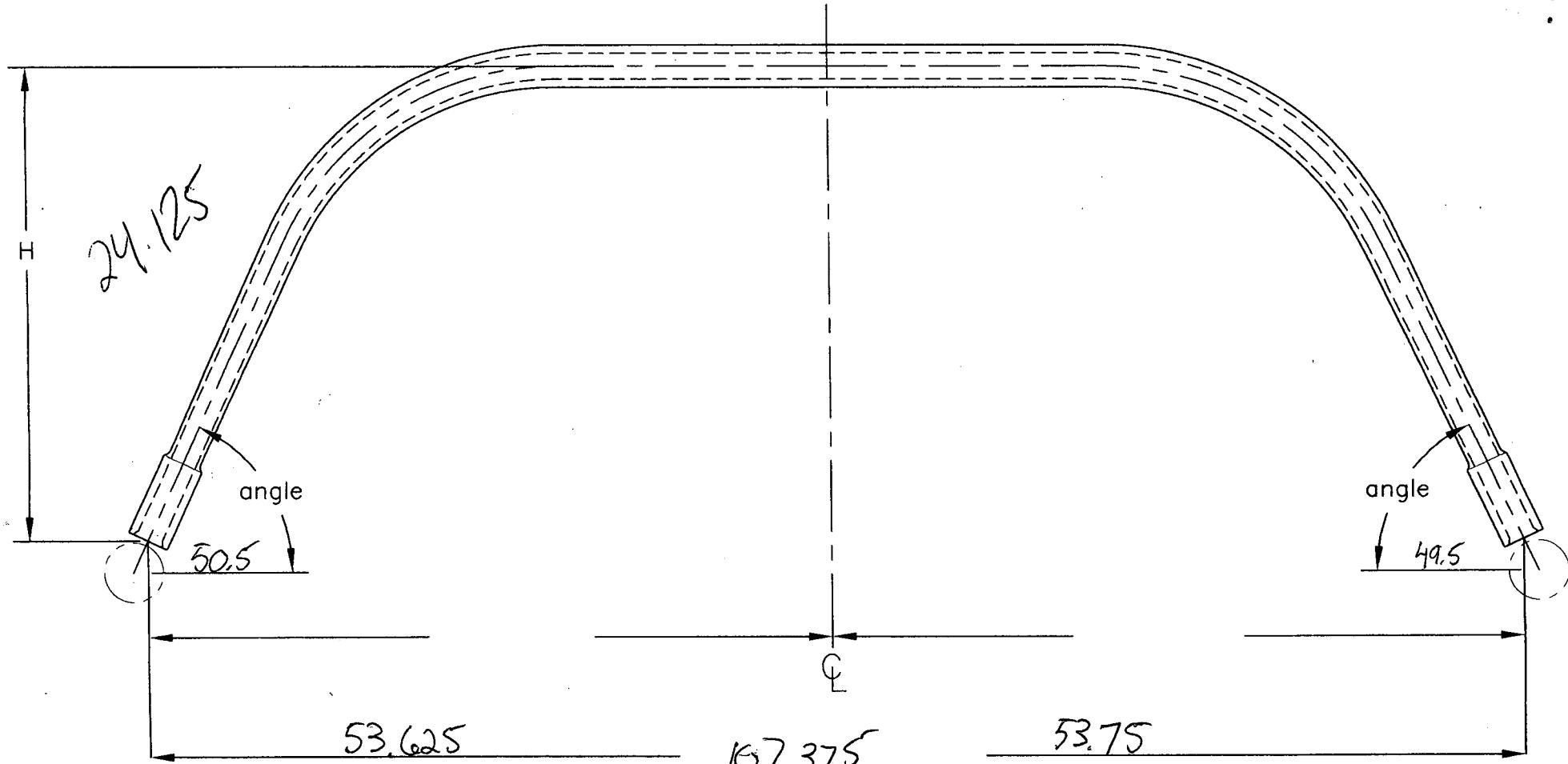
RELEASED  
05-06-09



COPRIGHT © 2001 BY DART AEROSPACE LTD.		DESIGN	DRAWN BY	DART		DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE 'EXPRESS' CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	APPROVED			DRAWING NO.	REV. B
						D412-664-243	SHEET 3 OF 3
		DATE				TITLE	SCALE
		05.02.04				CROSSTUBE ASSEMBLY (412 HI AFT)	1:1

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25252

SHOP COPY  
RETURN TO  
ENGINEERING



DATE: 06-05-11

DESCRIPTION: 412-664-203

BATCH NO: 25625

DRAWING: D412-664-203

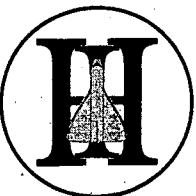
H: 24.37

1/2 SPAN:  $53.72 \pm 0.06$

TOTAL SPAN: 107.44

ANGLE:  $50.5^\circ$

*J*  
06-05-11



# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. № 34150

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of (5) cross tube (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (1) P/N D212-664-101 S/N B26238  
Qty (1) P/N D058-676-201 S/N B19626  
Qty (2) P/N D412-664-203 S/N's B26675 & B25652  
Qty (1) P/N D206-667-203 S/N B25608

RADIOGRAPHY

ULTRASONIC

PENETRANT

MAGNETIC PARTICLE

EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (5) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)  
Ardrox 970P25E Batch #04B503.

(5) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

DATE May 17, 2006

INSPECTION STAMP(S) Not Required

### CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

00001260

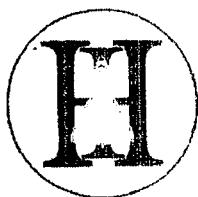
ADDRESS:

CONTACT NAME:

LABOUR	@	\$
MATERIALS	@	GST
TRAVEL EXPENSES	@	PST
HOTEL EXPENSES	@	

INVOICE NO.

TOTAL \$



# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél: (514) 636-1000 • Fax: (514) 636-0031

W.O. № 34150

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### TESTED COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG

OPERATED BY:

BASED AT:

### TEST SECTION REQUIREMENTS

Carry out FPI of (5) cross tube (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (1) P/N D212-664-101 S/N B26238  
Qty (1) P/N D058-676-201 S/N B19626  
Qty (2) P/N D412-664-203 S/N's B26675 & B25652  
Qty (1) P/N D206-667-203 S/N B25608

RADIOGRAPHY

ULTRASONIC

PENETRANT

MAGNETIC PARTICLE

EDDY CURRENT

### TEST SECTION RESULTS

Fluorescent penetrant inspection was performed in accordance with the above requirements on (5) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)  
Ardrox 970P25E Batch #04B503.

(5) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

DATE: May 17, 2006

INSPECTED BY:

  
S. FLETCHER

INSPECTION  
STAMP(S)

Not Required

### CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER: 00001260

ADDRESS:

CONTACT NAME:

LABOUR	@	\$
MATERIALS	@	
TRAVEL EXPENSES	@	GST
HOTEL EXPENSES	@	PST

INVOICE NO.

TOTAL \$